Dart Aerospace Ltd.

Date: Tuesday, 27/02/2007 1:03:12 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 30977
Estimate Number : 12342
P.O. Number : N/A
This Issue : 27/02/2007 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : NA **Type** : MACHINED PARTS
Previous Run : 26339
Written By :
Checked & Approved By :
Comment : Est Rev:A Removed from 9 Digit 06-03-22 JLM

Drawing Name : PEDAL LOCK
Part Number : D3368041
Drawing Number : D3368 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 06/03/2007 **Qty:** 5 **Um:** Each

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	D33681	Pedal Lock Base

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3368-1	BASE	B23534

Seq. #:	**Machine Or Operation:**	**Description :**
2.0	D33683	Pedal Lock Cover

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3368-3	COVER	B22940

Seq. #:	**Machine Or Operation:**	**Description :**
3.0	D27287	Decal

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2728-7	Decal	B22554

Seq. #:	**Machine Or Operation:**	**Description :**
4.0	D33737	Cam Lock unalike C316A C145A ALike C420A

X

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3373-7	Cam Lock	
2	D3373-7D		B16435
3	D3373-7KA		B22944

SB 07/03/07

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Tuesday, 27/02/2007 1:03:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** PEDAL LOCK

Job Number: 30977 **Part Number:** D3368041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D33853	Hinge

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3385-3	Hinge	B22387

Seq. #:	Machine Or Operation:	Description :
6.0	238028	3/16" Dowel Pin .5" long

Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
3	238-028	Ø3/16" Dowel Pin ½" long	M17848 ~~M16684~~

Seq. #:	Machine Or Operation:	Description :
7.0	385039	8-32 Flat screw

Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	385-039	Flat Head Screw	M17356

Seq. #:	Machine Or Operation:	Description :
8.0	D33841	Cyclic Sock

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3384-1	Cyclic Sock	B26372

Seq. #:	Machine Or Operation:	Description :
9.0	CBL460	Loop Sleeve

Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	CBL-460	Loop Sleeve	M00644

SB 07/03/07

H:\FORMS\...

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ________________ **PAR #:** ______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 27/02/2007 1:03:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** PEDAL LOCK

Job Number: 30977 **Part Number:** D3368041

Job Number:

Seq. #:	Machine Or Operation:	Description :
10.0	CBL1240	Cable

Comment: Qty.: 2.3333 f(s)/Unit Total : 11.6665 f(s)
Pick:
Qty Part Number Description Batch
28" CBL-1240 Cable M 102439

Seq. #:	Machine Or Operation:	Description :
11.0	AN960416	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 AN960-416 Washer M 5519

Seq. #:	Machine Or Operation:	Description :
12.0	HX81	1/4"-20 SHCS 3/8" long

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 HX-81 ¼"-20 SHCS 3/8" long M 16971 SB 07/03/02

Seq. #:	Machine Or Operation:	Description :
13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel. Discard the rest.

2-Fabricate D3371-5 Cam Lock as per Dwg D3371Identify as D3371-5 SB 07/03/01 (S)

3-Assemble lock mechanism and cam and install decal as per Dwg D3368. Apply 262 locktite to lock body nut. Ensure mechanism works properly (open/close).
Pick:
Qty Part Number Description Batch
A/RN/A 262 Locktite M 102855

4-Assemble lanyard to cyclic sock as per Dwg D3384

5-Assemble D3384-047 to D3368-051 using ¼"-20 socket head cap screw and washer as per Dwg D3368

6-Ensure that keys are attached to D3368-041. SB 07/03/02 (S)

 Form: rprocess

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** PEDAL LOCK

Job Number: 30977 | **Part Number:** D3368041

Job Number:

Seq. #:	Machine Or Operation:	Description :
14.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

07/03/05 (5)

15.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_______

07/03/05 (5)

16.0	QC21	FINAL INSPECTION/W/O RELEASE

(5)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/06

Job Completion

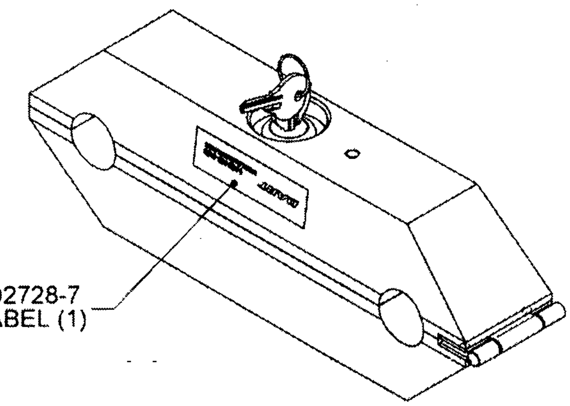
07-03-06

Form: rprocess

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3368	REV. B SHEET 1 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

RELEASED

25/04/22



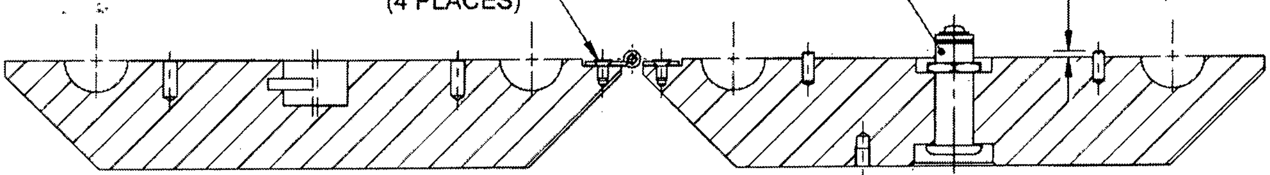
D2728-7
LABEL (1)

PEDAL LOCK SHOWN LOCKED WITH KEY

△1 MACHINE SCREW
#8-32 x 0.313 LONG,
(4 PLACES)

D3373-7 CAM
LOCK ASS'Y

0.100 (2 PLACES)

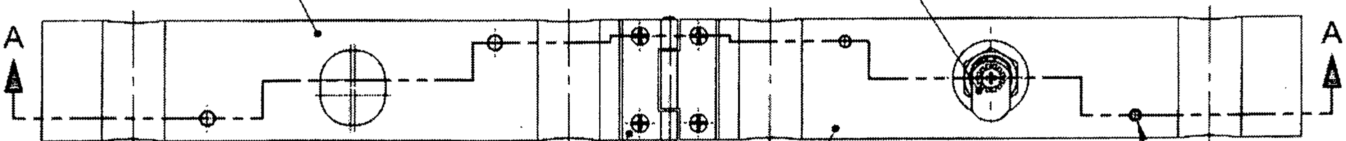


SECTION A-A

D3371-5 CAM (1),
SQUARE WASHER SPACER (1),
EXTERNAL TOOTH LOCK WASHER (1),
#10-32 UNF PAN CROSS HEAD SCREW (1).
(AS PER DRAWING D3373)

D3368-1 BASE (1)

A



A

△B D3385-3 HINGE (1)

D3368-3 COVER (1)

STD. GROUND DOWEL
PIN ϕ3/16 x 0.50 LONG
(2 PLACES)

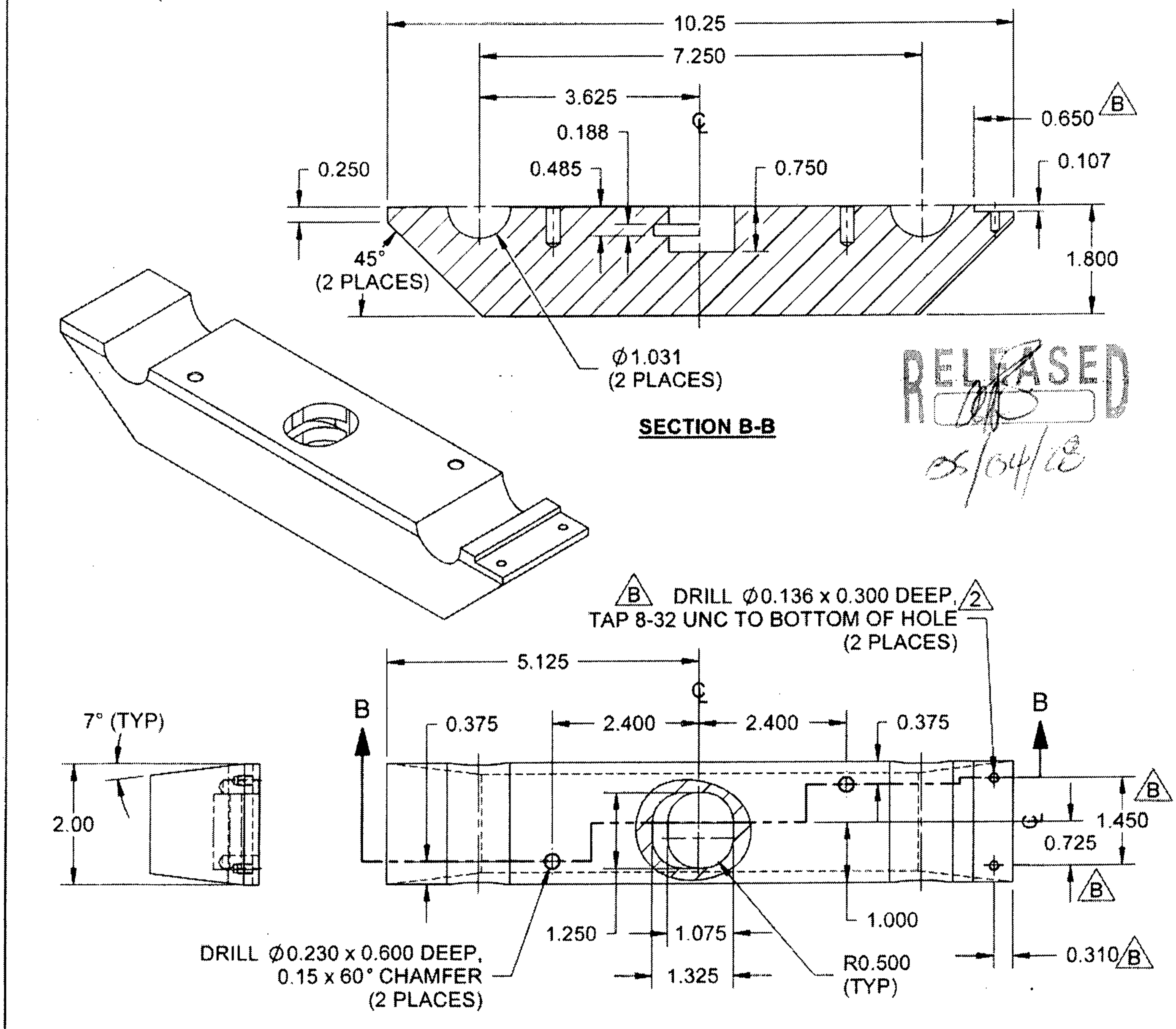
D3368-051 PEDAL LOCK ASSEMBLY

W/O 30977

NOTES:

1) POSSIBLE SUPPLIER: SPAENAUR P/N 385-044
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3368 — REV. B — SHEET 2 OF 3
DATE 05.03.22		TITLE PEDAL LOCK — SCALE 1:2.5

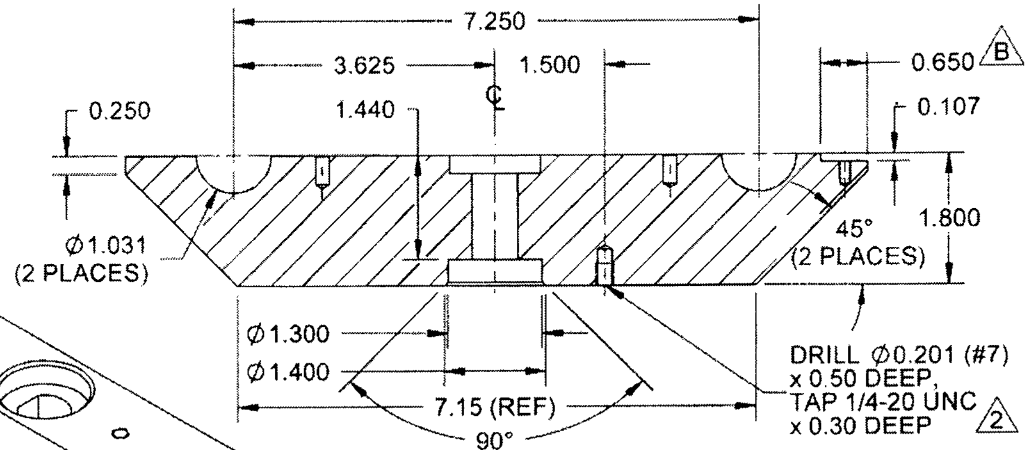


D3368-1 BASE

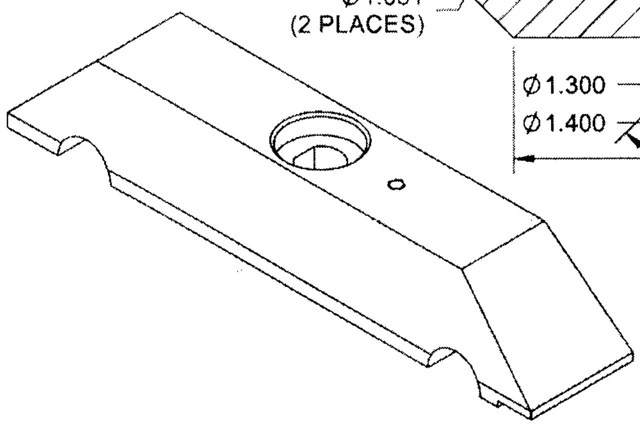
NOTES:

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
   (REF. DART SPEC. M6061T6B)
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

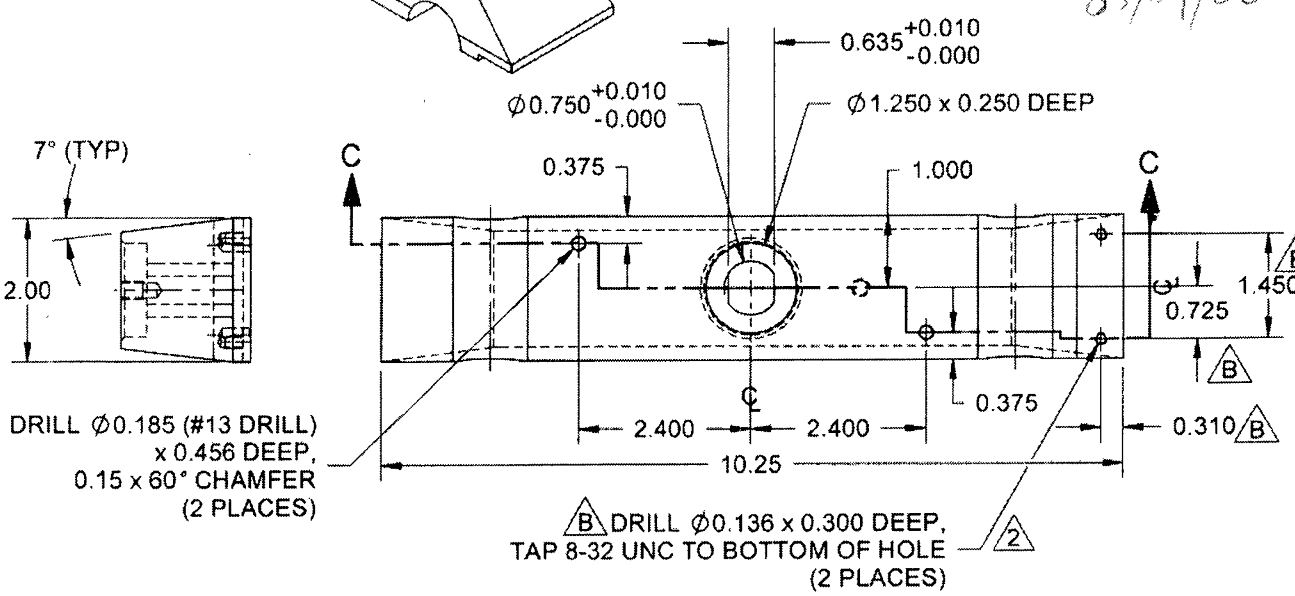
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3368	REV. B SHEET 3 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2.5



SECTION C-C



RELEASED 05/04/26

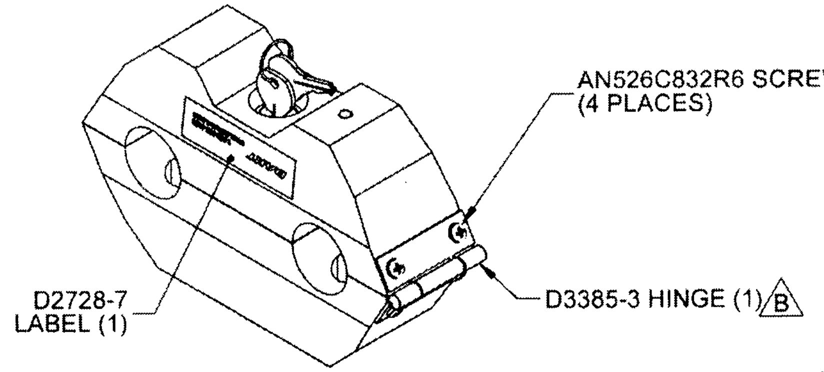


D3368-3 COVER

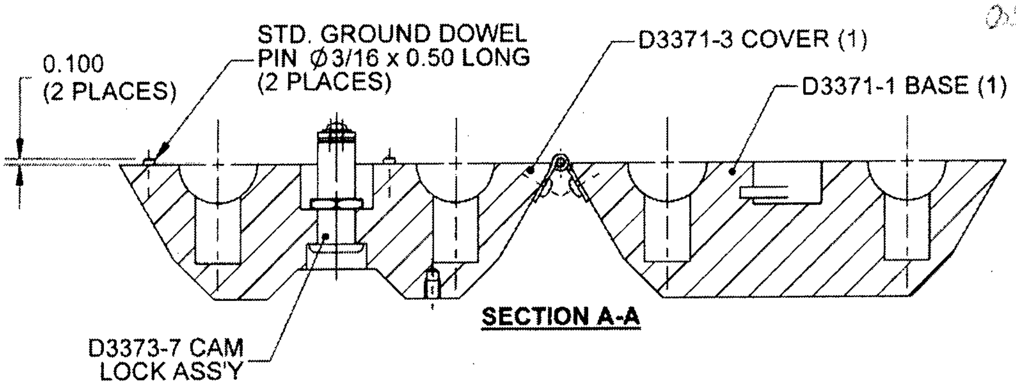
NOTES:

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

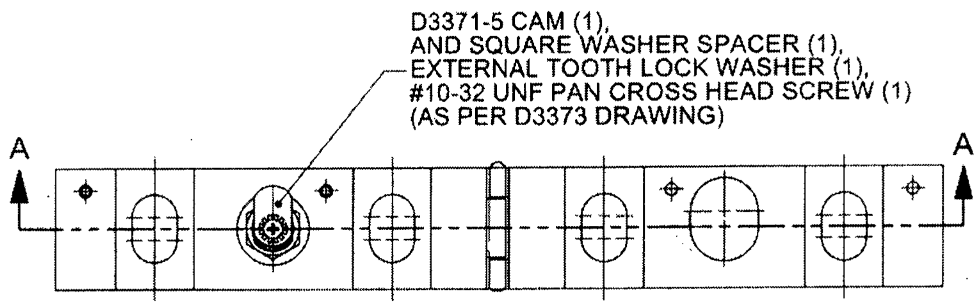
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



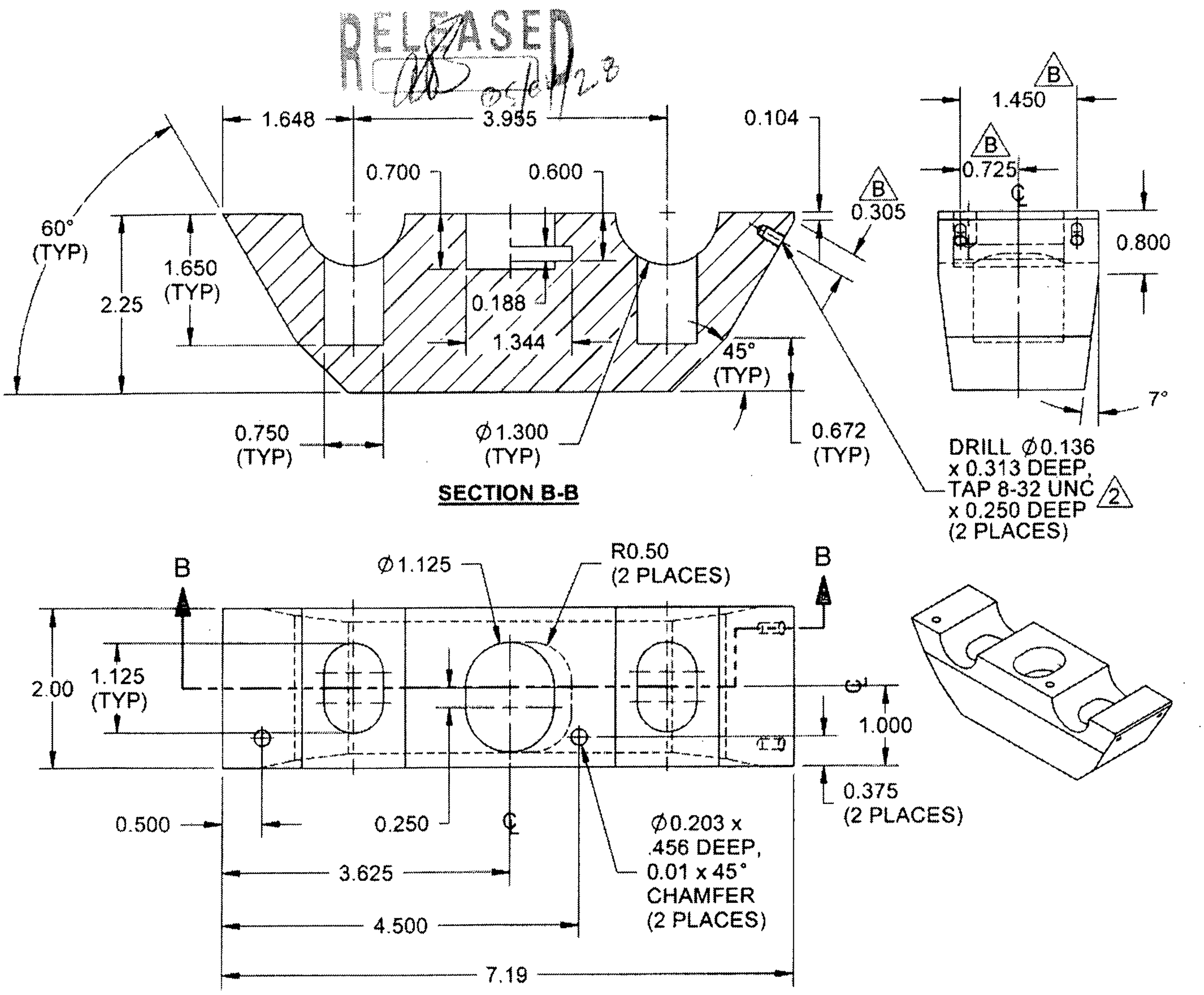
D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) ALL DIMENSIONS ARE IN INCHES

W/O 30977
CL05/03/01

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



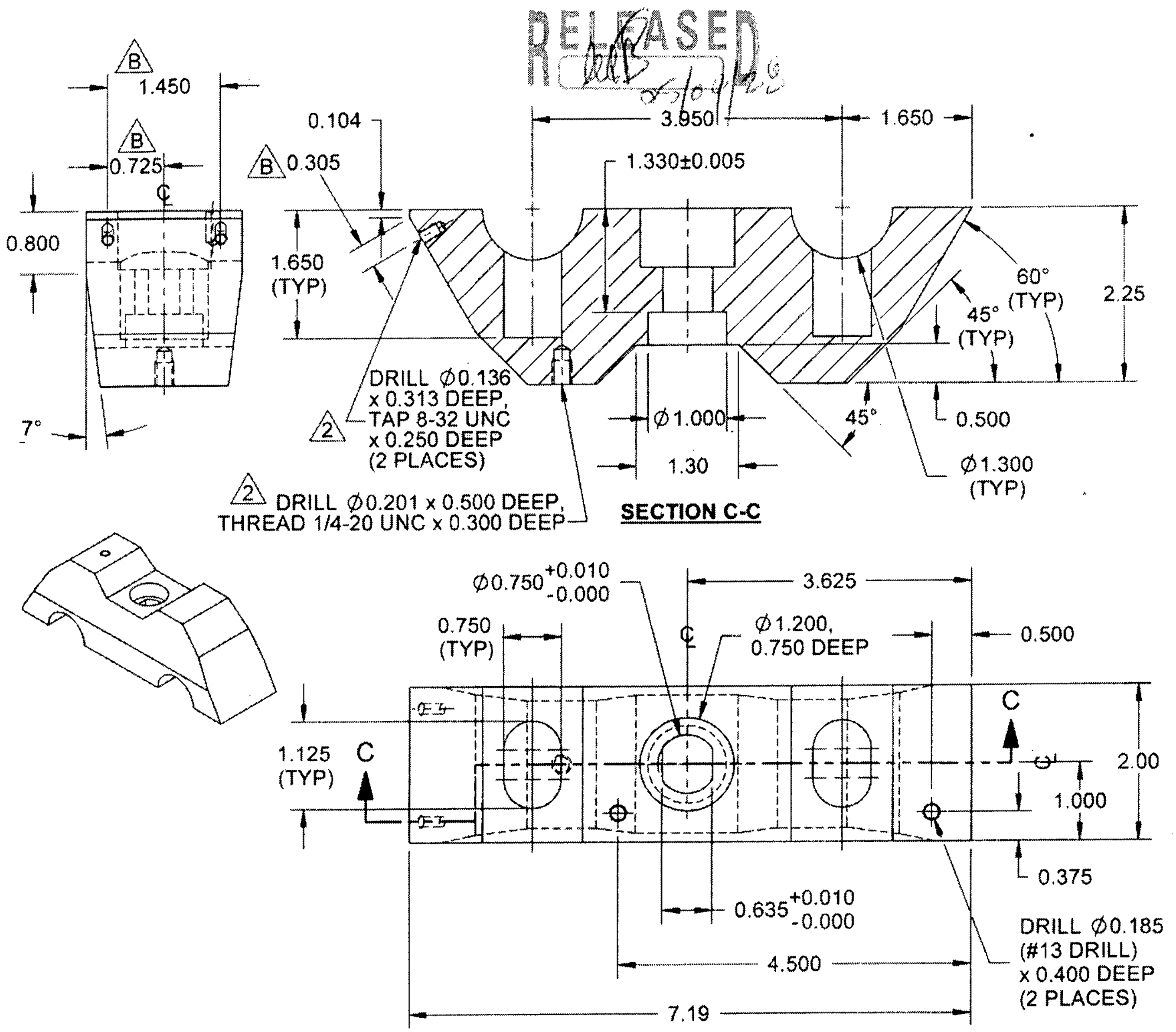
D3371-1 BASE

NOTES:

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
   (REF. DART SPEC. M6061T6B)
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

W/O 30977
C207/03/01

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



D3371-3 COVER

NOTES:

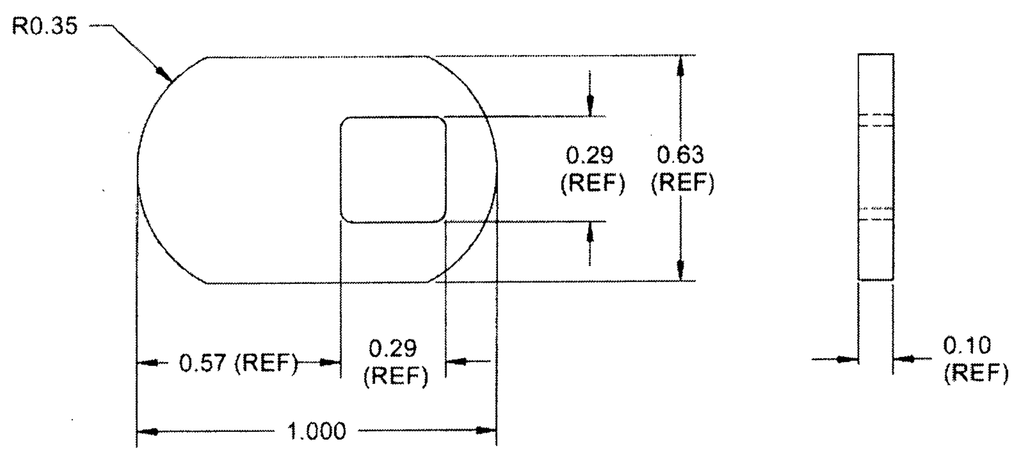
1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
   (REF. DART SPEC. M6061T6B)
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

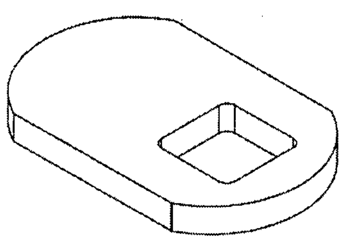
W/O 30977
C2071031

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED 05/04/28

SPECIFICATION CONTROL DRAWING





D3371-5 CAM

NOTES:

1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

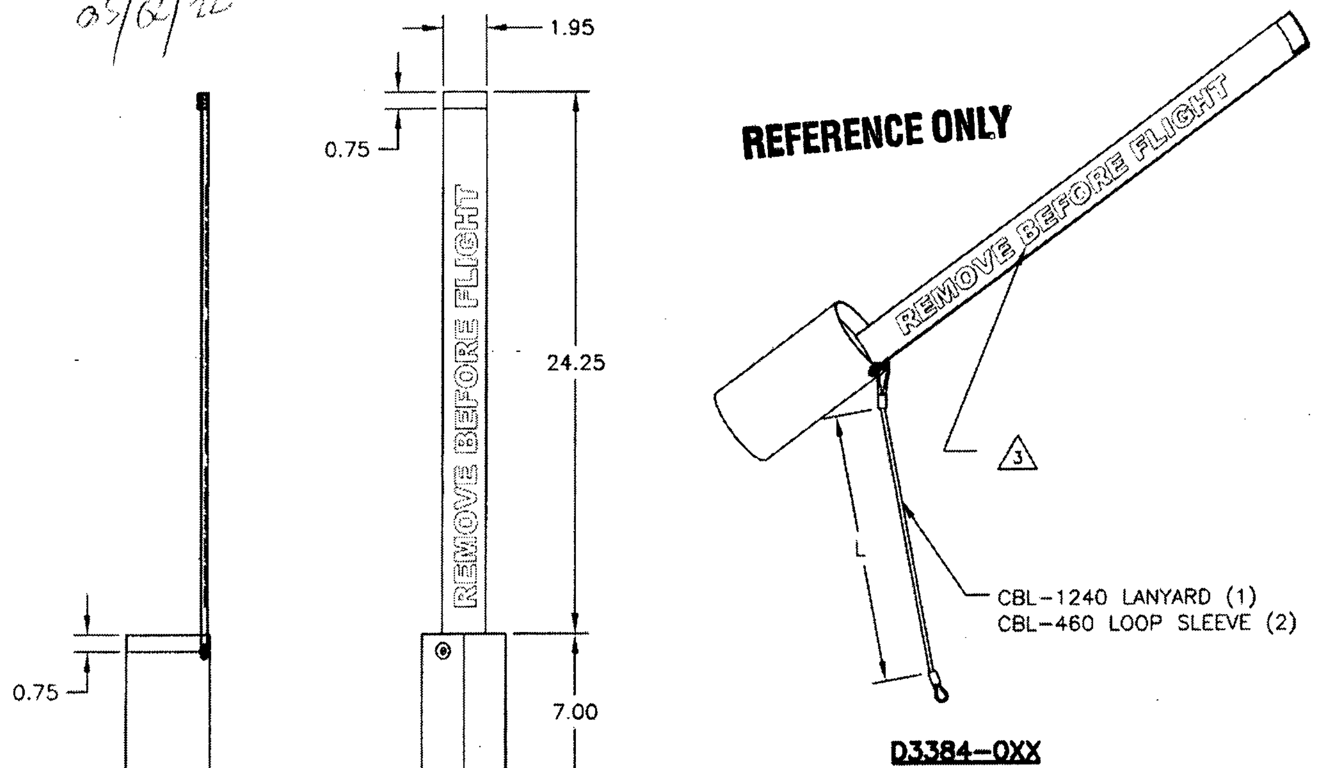
W(0830977)
C(20)/03/01

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3384 — REV. A — SHEET 1 OF 1
DATE 05.01.20		TITLE SOCK ASSEMBLY — SCALE NTS

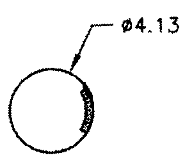
REV		DATE	DESCRIPTION
A		05.01.20	NEW ISSUE
A1		05.04.19	ADDED D3384-049

RELEASED
05/02/22



D3384-0XX

P/N D3384-0XX	L (in)
D3384-041	24
D3384-043	8
D3384-045	20
D3384-047	28
D3384-049	30



D3384-1 SOCK

NOTES:
1) POSSIBLE SUPPLIER: TULMAR
2) THREAD: STITCHING IAW D-6193 6 TO 10 STITCHES PER INCH
3) STENCIL THE FOLLOWING: REMOVE BEFORE FLIGHT ON BOTH SIDES OF STRIP WITH 1" LETTERS
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O 30977
CL 07/03/01